

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001616**Date Inspected:** 24-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	None	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

Caltrans Quality Assurance Inspector Gabriel Quintana (QA Inspector) arrived at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to observe fabrication and Quality Control Inspectors (QC Inspectors) perform their duties and responsibilities as specified in the contract documents, approved plans, fabrications documents and Special Provisions for this project. While on site the QA Inspector observed the following:

Production Monitoring test (PMT) and Fabrication

Caltrans QA Inspector performed Ultrasonic Test (UT) inspection on six Production Monitoring Tests (PMT's) for Deck Panel DP062-001. Welding of the PMT's was completed and on 02-24-2008 and UT inspected by a ZPMC QC Inspector. Caltrans QA Inspector UT examination revealed three areas of the closed rib Partial Joint Penetration (PJP) groove welds that had penetration of 73% to 78% with lengths in the range of 5mm to 10mm. QA Inspector found each of the six the welds inspected to be in compliance with the contract documents, approved plans, fabrications documents and Special Provisions for this project. See ultrasonic testing report TL-6027 Modified dated February 24, 2008 for more details.

QA Inspector identified specimens on six Production Monitoring Tests (PMT's) for Deck Panel DP062-001 to be removed for macro testing.

QA Inspector conducted an inventory in Bay 1 of the Floor Beams in work and forwarded the information to Caltrans Task Leader Jimmy Cochran.

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Summary of Conversations:

No communications took place between the QA and QC Inspector.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Quintana,Gabriel	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
